Tuesday, 8/21/2007 3:43:29 PM Kim Johnston User: **Process Sheet** : TUBE Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 34183 **Estimate Number** : 11172 : D22827 **حالہ** : **Part Number** P.O. Number S.O. No. : NA : 8/21/2007 **Drawing Number** D2282 REV E This Issue ; N/A Prsht Rev. Project Number : MACHINED PARTS ; E First Issue **Drawing Revision** : 33417 : NA Material Previous Run : 9/20/2007 Each Due Date Written By Checked & Approved By Removed from 9 Digit 05-12-02 JLM Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 1.0 M304TR0675W091 304 RD Tube .675 x .091W Comment: Qtv.: 0.0699 f(s)/Unit Total: 13.9860 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA190 2-Deburr 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 4.0 Comment: SECOND CHECK 5.0 PACKAGING 1 PACKAGING RESOURCE #* Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

TEP	PROCEDURE CHANGE				Annroyal	
EP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: _	PAR #: _	Fault Category:	NCR: Yes No DQA:	Date: 67/09/ 2/
			QA: N/C Closed:	Date:

		WORK ORD	ER NON-CONFORMAN	CE (NCR)			
	Description of NC		Corrective Action Section E	3	Varification		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng

NOTE: Date & initial all entries

Date:

Tuesday, 8/21/2007 3:43:29 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Part Number: D22827

Job Number: 34183

Seq. #:

Job Number:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



303

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
DATE	STEP	P PROCEDURE CHANGE			Ву	Date	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	Fault Category:	NCF	R: Yes	No DQ	A:	Date:		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E	3	Verification			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
								:	

NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ___

DART AEROSPACE LTD	Work Order:	34183
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.010	0.796				
+/-0.010	0.488				
+/-0.010	0.671				
	:				
					····
					<u> </u>
	+/-0.010 +/-0.010	Tolerance Dimension +/-0.010	Tolerance Dimension Accept	Tolerance Dimension Accept Reject	Tolerance Dimension Accept Reject Inspection +/-0.010

Measured by: DJP	Audited by: J.L	Prototype Approval:	N/A
Date: 07/09/20	Date: 04/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	0.795 was 0.750	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM	R
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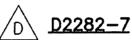
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		W	1000	D2282 SHEET 1 OF 2			
	DATE		1 1474/2	TITLE SCALE			
	05.06.07			HANDLE TUBES 1:1			
	Α		94.10.14	NEW ISSUE			
	В		95.03.23	RE-DESIGN			
	С		97.10.20	CORRECTED NUMBERING SCHEME			
	D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750			
	Ε		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030			



2.375 _{0.020}	0.795

Ø0.675 (REF) Ø0.493 (REF)

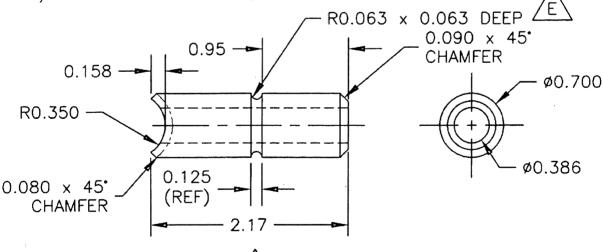
D2282 - 3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750) UNE ONTROLLED COL
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING**

SUBJECT TO AMENDME

WITHOUT NOTICE

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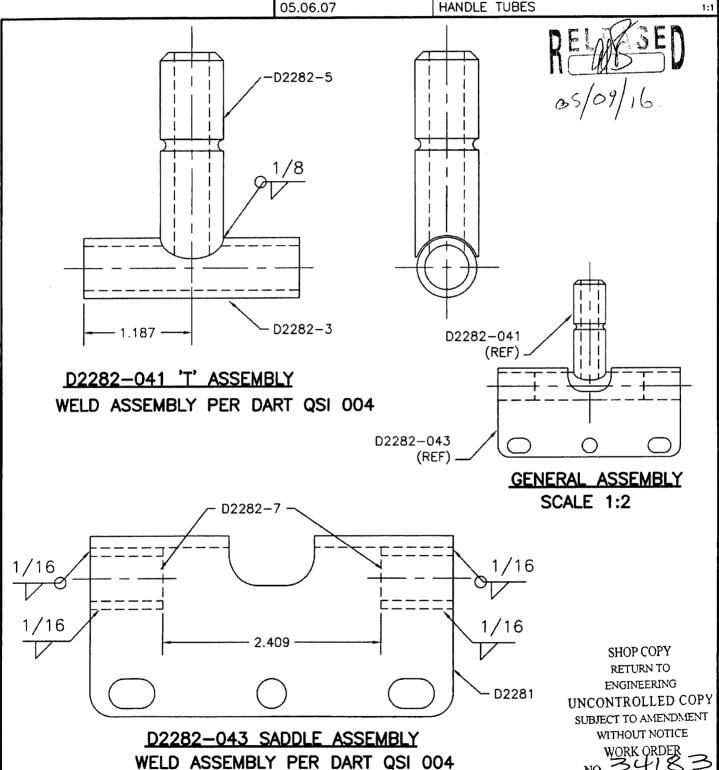
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D2282-5

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DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
U'	1 arb	D2282	SHEET 2 OF 2
DATE	1 446/	TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



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